Recommended Starting Speeds and Feeds [SFM]

Material Group		KC410M			KC520M			KC725M			KCK15			KCPM20			KCPK30		
P	1	–	–	–	–	–	–	860	**750**	700	–	–	–	1810	**1590**	1470	1485	**1300**	1210
	2	–	–	–	–	–	–	720	**630**	530	–	–	–	1120	**1010**	910	920	**830**	750
	3	–	–	–	–	–	–	660	**560**	460	–	–	–	1010	**910**	830	830	**750**	680
	4	–	–	–	–	–	–	590	**490**	390	–	–	–	760	**700**	630	620	**575**	520
	5	–	–	–	–	–	–	490	**440**	390	–	–	–	910	**820**	750	850	**760**	690
	6	–	–	–	–	–	–	430	**330**	260	–	–	–	630	**550**	475	520	**450**	–
M	1	–	–	–	–	–	–	560	**490**	450	–	–	–	730	**655**	570	680	**600**	515
	2	–	–	–	–	–	–	510	**430**	360	–	–	–	670	**580**	520	610	**530**	460
	3	–	–	–	–	–	–	380	**330**	260	–	–	–	530	**475**	410	475	**430**	380
K	1	–	–	–	880	**800**	710	–	–	–	1380	**1255**	1115	1180	**1070**	960	965	**875**	780
	2	–	–	–	690	**620**	580	–	–	–	1095	**975**	910	940	**840**	770	770	**690**	630
	3	–	–	–	580	**520**	470	–	–	–	920	**815**	750	790	**700**	650	645	**575**	530
N	1–2	3990	**3550**	3270	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	115	**100**	80	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	115	**100**	80	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	150	**115**	80	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	200	**150**	100	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LE	.003	**.007**	.014	.003	**.005**	.010	.002	**.004**	.009	.002	**.004**	.008	.002	**.004**	.008	.F..LE
.E..LD2	.004	**.010**	.020	.003	**.008**	.015	.002	**.007**	.013	.002	**.006**	.012	.002	**.006**	.012	.E..LD2
.E..GB2	.007	**.014**	.025	.005	**.011**	.018	.004	**.009**	.016	.004	**.009**	.015	.004	**.008**	.014	.E..GB2
.S..GB2	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..GB2

NOTE: Use "Light Machining" values as starting feed rate.